

Work Order ID 129449

February-09-15 1:38:41 PM

129449

Page 1

Item ID: D350-636-016

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH, Run-on Landing Wearplates, DART(Apical) Cylind./Aerazur Float Comp.

Start Date: 2/09/15 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 2/13/15 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4168-042	B								

100	Document Control	0.00							DAG 38 9-89
-----	------------------	------	--	--	--	--	--	--	-------------------

100

DC

Doc.Control -USB or Paperwork

Memo
record fwd angle: 89.4° Doc

Photocopy blue file and type labels per PPP D350-636-016 CHG 005

15-04-09

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Item ID: D350-636-016

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH, Run-on Landing Wearplates, DART(Apical) Cylind./Aerazur Float Comp.

Start Date: 2/09/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/13/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

110

Skidtubes

Skidtubes

0.00

0.00

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside
AFT end per dwg D41683- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16",
then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN
first side. Repeat process on second side.***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP
WHEN DRILLING FIRST SIDE***4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade
fitting, section R-R and open to 0.500"

6- Drill most FWD wearplate hole using DT9678 locating of 66.54" hole

7- Open up holes of Detail J to 0.297" (total of 2 holes per side) +.201" (total of
one hole per side) as per dwg D4168.8- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left
from bending as per QSI 004A/R Aluminum Rod batch: M130812

9- Grind welds flush as per Dwg D4168

15-3-9

DGL 15-3-9

786 15-03-10

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Item ID: D350-636-016

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N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube RH, Run-on Landing Wearplates, DART(Apical) Cylind./Aerazur Float Comp.

Stop

NS2

Start Date: 2/09/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/13/15

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC10- Inspect visual per QSI004- ground welds	0.00							
120									DAS
QC	Memo	0.00							9
Quality Control									9-89
130	QC5- Inspect part completeness to step on W/O	0.00							
130									DAS
QC	Memo	0.00							9
Quality Control									9-89
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

① 1503-10 DAS 9 9-89

① 1503-10 DAS 9 9-89

1 0 15-3-10

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Item ID: D350-636-016

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N900040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube RH, Run-on Landing Wearplates, DART(Apical) Cylind./Aerazur Float Comp.

Stop *NS2*

Start Date: 2/09/15 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 2/13/15 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #**Plan
Code**

**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

1 Ø 15-3-10 16

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Item ID: D350-636-016

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N900040100Setup Start ***NS1***

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Start Date: 2/09/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/13/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
160									
Skidtubes									
Skidtubes	Memo	0.00							
	1-Open up holes using hole saw of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D4168.								
	2-Open up holes using hole saw of Detail K to 0.750" (total of 4 holes per side) as per dwg D4168.								
	3- Open float hole to 0.500" using uni-bit (4 per side) and Run on wearplate holes to .375" 4 per side								
	4-Chamfer holes of Detail K,L, ground handling and float holes per dwg D4168 (welding instructions on sheet 9)								
	5-Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: <u>131574</u> exp. date: <u>15-10-21</u>								
	ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: <u>M127865</u>								
	9- At section AP-AP drill out x-bolt spacer to 0.404"								

*Doc 15-3-10**15-3-10**OK 15-03-13*

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Item ID: D350-636-016 Accept ***N900040100*** Setup Start ***NS1***
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 Start Date: 2/09/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 2/13/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	10-Grind welds flush as per Dwg D4168								
	11-Spot face ground handling holes section (total of 4 places per side) as per dwg D4168								
	12- C'bore section CH-CH. ADJUST TOOLING AS REQUIRED. VERF BY: <u>DD</u>								
	13- Deburr holes, ensure tube is free of all scratches before sending to paint.								
	***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING HOLE IN TUBE ***** *****REF TO W/O BATCH: <u>N/A</u> *****								
170	QC10- Inspect visual per QSI004- ground welds	0.00							

170

QC

Quality Control

Memo

0.00

DAS
38
9-89

15-03-27

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Item ID: D350-636-016

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N900040100

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo ***VERIFY C'BOARD IS GOOD***	0.00 0.00				1			DAS 38 9-89 15-03-27
190 *190* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.	0.00 0.00				1			15-3-30 DSC
200 *200* SprayPaint Spray Painting	 Memo 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>130992</u> 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>131841</u>	0.00 0.00				1			DAS 41 9-89 15-3-31

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Item ID: D350-636-016 Accept *N900040100* Setup Start *NS1*
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 Start Date: 2/09/15 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 2/13/15 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC14- Inspect Spray Paint	0.00							
210									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								
230		0.00							
230	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing	1- Install inserts as per Dwg D4168								
	2-Inspect for Foreign Objects								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D4168								
	SIKA FLEX 241								
	BATCH: 14131574								
	EXP DATE: 15/10								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	A/R 55-o'ring lube batch: 14131349 RTU 598 M125792 exp 15/10								
	5-Coat all exposed fasteners with "LPS Procyon" batch: 14122900								

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Start Date: 2/09/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/13/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 *240* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			DAS 38 9-89 15-04-06
250 *250* Packaging Packaging	Pick Kit Memo If making a D350-636-216 pick kit will only requires: 1 X AN3C37A 1 X AN3C34A 1 X AN3C42A 2 X D3493-1	0.00 0.00							DAS 46 9-89 APR 05 2015
260 *260* QC Quality Control	QC4- 100% Inspect kits for completeness Memo *****ensure antiseize is on AN8C21A bolts*****	0.00 0.00				1			DAS 38 9-89 15-04-09

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Item ID: D350-636-016

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N900040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube RH, Run-on Landing Wearplates, DART(Apical) Cylind./Aerazur Float Comp.

Stop *NS2*

Start Date: 2/09/15 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 2/13/15 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	Packaging	0.00							
270	Packaging								ET
Packaging	Memo	0.00							15-04-09
	Identify and pack for shipping as per PPPD350-636-016								
	Location: <u>EG 71</u>								
	PPP rev: _____								
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

DAS
06
9-89

MCS 15-04-10

15-4-9

Picklist Print

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Work Order ID: 129449

129449

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube RH, Run-on Landing Wearplates, DART(Apical) Cylind./Aerazur Float Comp.

Start Date: 2/09/15

Required Date: 2/13/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC
11.04.14 ecn11-553 DD verf:EC
per NCR 11-906 DD verf:EC
594 DD VERF:JLM
IPP Rev:B
IPP Rev:C 11.10.18 as
IPP REV:D 13.08.28 PER ECN13-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C34A		Purchased	No			230	Each	10.0000	1	1			
AN3C34A									**			15/04/01	
BOLT													

Location

Loc Qty

Loc Code

ST347

10

M131618

VI

m127044

10

AN3C36A		Purchased	No			230	Each	209.0000	4	4			
AN3C36A									**			15/04/01	
Bolt													

Location

Loc Qty

Loc Code

FG

24

M131856

VD

101261

4

116590

10

122204

10

FP001

19

m129907

19

ST338a

50

m130874

50

ST347

80

m131367

80

ST348

36

m129907

36

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129449

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube RH, Run-on Landing Wearplates, DART(Apical) Cylind./Aerazur Float Comp.

Start Date: 2/09/15

Required Date: 2/13/15

AN3C37A

Purchased No

230 Each

Start Qty: 1.00
227.0000 1 1

Required Qty: 1.00

AN3C37A

BOLT

DAS
38
9-89

**

DAS
86
9-89

DAS
46
9-89

Location

Loc Qty

Loc Code

ST338a

227

M128773

80

M129650

77

M131367

70

AN3C42A

Purchased No

230 Each

35.0000 1 1

AN3C42A

Bolt

DAS
38
9-89

**

DAS
46
9-89

DAS
86
9-89

APR 05 2015

Location

Loc Qty

Loc Code

FG

5

121103

5

ST347

30

m130485

30

D3488-042

Manufactured No

230 Each

11.0000 1 1

D3488-042

Blade Fitting RH

**

Bl 13104101

Location

Loc Qty

Loc Code

FP001

11

B128804

125899

8

125900

3

D3490-1

Manufactured No

160 Each

9.0000 4 4

D3490-1

Cross Bolt Spacer

**

BE15-03-12

B128984 x4

Location

Loc Qty

Loc Code

LG001

9

125902

9

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Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube RH, Run-on Landing Wearplates, DART(Apical) Cylind./Aerazur Float Comp.

Start Date: 2/09/15

Required Date: 2/13/15

D3490-3

Manufactured No

160

Each

35.0000

Start Qty: 1.00

4

4

Required Qty: 1.00

D3490-3

Cross Bolt Spacer

8215-03-12

B129055 *4

Location

Loc Qty

Loc Code

LG001

35

128533

35

D3492-1

Manufactured No

230

Each

212.0000

8

8

D3492-1

Plug

15104101

Location

Loc Qty

Loc Code

FP001

212

125904

5

128509

173

129057

34

D3492-3

Manufactured No

230

Each

122.0000

8

8

D3492-3

Plug

15104101

Location

Loc Qty

Loc Code

FP001

122

125905

2

128476

120

D3873-1

Manufactured No

230

Each

118.0000

7

7

D3873-1

Bushing

15104101

Location

Loc Qty

Loc Code

FP001

13

126709

13

ST063

105

128405

105

V7

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Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube RH, Run-on Landing Wearplates, DART(Apical) Cylind./Aerazur Float Comp.

Start Date: 2/09/15

Required Date: 2/13/15

D4154-041

Manufactured No

230

Each

3.0000

Start Qty: 1.00

Required Qty: 1.00

D4154-041

Wearplate Assembly

**

ll isloalor

Location

Loc Qty

Loc Code

FP002

3

B129058

120226

3

D4170-1

Manufactured No

230

Each

149.0000

4

4

D4170-1

Bushing

**

B15-03-12

Location

Loc Qty

Loc Code

LG001

149

107896

72

119639

44

123940

33

D4171-1

Manufactured No

230

Each

44.0000

1

1

D4171-1

Bushing

**

ll isloalor

Location

Loc Qty

Loc Code

ST096

44

125038

3

129060

41

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Parent Item Name: Skidtube RH, Run-on Landing Wearplates, DART(Apical) Cylind./Aerazur Float Comp.

Start Date: 2/09/15

Required Date: 2/13/15

MS21043-3

Purchased

No

230

Each

Start Qty: 1.00
1,235.000 5 5

Required Qty: 1.00

MS21043-3

Nut

**

15/04/01

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

169

m130673

169

GA

17

m130673

17

ST304

969

m131340

969

NAS1149C0363R

Purchased

No

230

Each

906.0000 9 9

NAS1149C0363R

Washer

**

15/04/01

Location

Loc Qty

Loc Code

FP001

187

114742

187

GA

220

m130673

220

ST271

499

m130673

499

NAS1149D0863J

Purchased

No

250

Each

734.0000 2 2

NAS1149D0863J

Washer

**

125268

DAS
46
9-39

DAS
03
9-89

APR 05 2015

Location

Loc Qty

Loc Code

FP001

57

125484

57

ST260a

677

125268

577

125635

100

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Parent Item Name: Skidtube RH, Run-on Landing Wearplates, DART(Apical) Cy lind./Aerazur Float Comp.

Start Date: 2/09/15

Required Date: 2/13/15

NAS1515H3L

Purchased

No

230

Each

567.0000

Start Qty: 1.00

4

4

Required Qty: 1.00

***NAS1515H3I ***

Washer

**

ll 15104101

Location

Loc Qty

Loc Code

FG

40

102472

40

FP001

55

m127831

55

ST266

472

m127831

48

m130726

424

✓

NAS1611-010

Purchased

No

230

Each

148.0000

8

8

NAS1611-010

O-RING

**

ll 15104101

Location

Loc Qty

Loc Code

FP001

148

m130797

4

M130770

m131329

144

✓

NAS1611-013

Purchased

No

230

Each

726.0000

8

8

NAS1611-013

O-RING

**

ll 15104101

Location

Loc Qty

Loc Code

FP001

726

m130758

726

✓

D2744

Manufactured

No

110

Each

11.0000

1

1

D2744 ✓

Cap

**

BE15-03-10

*128212 *1*

Location

Loc Qty

Loc Code

LG001

11

125894

11

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Parent Item Name: Skidtube RH, Run-on Landing Wearplates, DART(Apical) Cylind./Aerazur Float Comp.

Start Date: 2/09/15

Required Date: 2/13/15

D2600-3-BENT-RH

Manufactured No

D2600-3-BENT-RH

Extrusion Bent RH

Location: 128986 110 Each

Start Qty: 1.00
1

Required Qty: 1.00
1

**

15-3-9 *[Signature]*

Location

Loc Qty

Loc Code

LG

128628

1

1

D2743

Manufactured No

D2743

Crossbolt Spacer

D2739

Manufactured No

D2739

350 I Beam

160

Each

0.0000

8

8

**

BE15-03-12
B129465 x8

160

Each

5.0000

1

1

**

15-3-10 *[Signature]*

Location

Loc Qty

Loc Code

LG002

128626

5

5

ALS4-1032-225

AELS8-1032-225

Purchased

No

ALS4-1032-225

Rivnut

230

Each

190.0000

4

4

**

[Signature] 1510401

Location

Loc Qty

Loc Code

FG

120

M127028

120

FP001

70

M131067

70

X1131582

X J

February-09-15 1:38:40 PM

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Page 8

Work Order ID: 129449

129449

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube RH, Run-on Landing Wearplates, DART(Apical) Cylind./Aerazur Float Comp.

Start Date: 2/09/15

Required Date: 2/13/15

AN8C35A

Purchased

No

230

Each

11.0000

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Bolt

**

Handwritten: 11 15/04/01

Location

Loc Qty

Loc Code

FG

5

121275

5

Handwritten: 11 131856

Handwritten: 11

FP001

6

m131367

6

AN6C44A

Purchased

No

230

Each

82.0000

4

4

AN6C44A

Bolt

**

Handwritten: 11 15/04/01

Location

Loc Qty

Loc Code

FG

2

103964

2

Handwritten: 11 131651

Handwritten: 11

FP001

6

m130863

4

m131367

2

ST286A

13

m130863

13

ST332

11

m130863

11

ST333

50

m131151

50

MS21083C8

Purchased

No

230

Each

57.0000

1

1

MS21083C8

Nut

**

Handwritten: 11 15/04/01

Location

Loc Qty

Loc Code

ST300

57

m131049

57

Handwritten: 11

February-09-15 1:38:40 PM

Shop Packet Print

Page 8

Picklist Print

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Page 9

Work Order ID: 129449

129449

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube RH, Run-on Landing Wearplates, DART(Apical) Cylind./Aerazur Float Comp.

Start Date: 2/09/15

Required Date: 2/13/15

D3631-1 Manufactured No

230 Each

Start Qty: 1.00
254.0000 8 8

Required Qty: 1.00

D3631-1

Washer

**

del 15/04/01

Location

Loc Qty

Loc Code

FP001

254

128320

154

128910

100

NAS1149C0332R

Purchased No

230 Each

4,097.000 4 4

NAS1149C0332R

WASHER

**

del 15/04/01

Location

Loc Qty

Loc Code

FP001

2140

m130325

2140

GA

2

125654

2

ST271

1955

125654

44

m130466

25

m131340

1886

D2745

Manufactured No

230 Each

217.0000 8 8

D2745

Bushing

**

del 15/04/01

Location

Loc Qty

Loc Code

ST010

136

127585

36

128480

100

ST012a

81

128089

81

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Page 9

Picklist Print

February-09-15 1:38:40 PM

Page 10

Work Order ID: 129449

129449

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube RH, Run-on Landing Wearplates, DART(Apical) Cyling./Aerazur Float Comp.

Start Date: 2/09/15

Required Date: 2/13/15

NAS1149C0832R

Purchased

No

230

Each

158.0000

Start Qty: 1.00

1

1

Required Qty: 1.00

NAS1149C0832R

Washer

Handwritten: 1510401

Location

Loc Qty

Loc Code

FP001

14

m114915

14

ST271

144

m125807

144

AN3C6A

Purchased

No

230

Each

464.0000

4

4

AN3C6A

Bolt

Handwritten: 1510401

Location

Loc Qty

Loc Code

CA

39

m128704

39

FG

10

122416

10

ST338a

415

m128769

415

MS21043-6

Purchased

No

230

Each

106.0000

4

4

MS21043-6

NUT

Handwritten: 1510401

Location

Loc Qty

Loc Code

FG

20

103693

20

FP001

86

m130325

2

m130726

84

Handwritten: 11 1316 B

Handwritten: 1510401

Picklist Print

February-09-15 1:38:40 PM

Page 11

Work Order ID: 129449

129449

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube RH, Run-on Landing Wearplates, DART(Apical) Cylind./Aerazur Float Comp.

Start Date: 2/09/15

Required Date: 2/13/15

D3493-1	Manufactured	No	250	Each	162.0000	Start Qty: 1.00 2 2	Required Qty: 1.00		
D3493-1						**		DAS	46
Washer	DAS 38 9-89							DAS 06 9-89	9-89
		<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
		FG		10					
		97201		10					
		ST046		152					
		125906		51					
		128755		101					
MS21083C8	Purchased	No	250	Each	57.0000	2 2			
MS21083C8						**		DAS	DAS
Nut	DAS 38 9-89							06 9-89	46 9-89
		<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
		ST300		57					
		m131049		57					
AN8C21A	Purchased	No	250	Each	21.0000	2 2			
AN8C21A						**			
Bolt	DAS 38 9-89								
		<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
		FG		2					
		123966		2					
		ST332		19					
		m131100		3					
		m131247		16					

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Page 12

Work Order ID: 129449

129449

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube RH, Run-on Landing Wearplates, DART(Apical) Cyliind./Aerazur Float Comp.

Start Date: 2/09/15

Required Date: 2/13/15

D2741

Manufactured No

250

Each

20.0000

Start Qty: 1.00

Required Qty: 1.00

D2741

Replacement Blade

DAS
38
9-89

**

128088

DAS
46
9-89

DAS
46
9-89

Location

Loc Qty

Loc Code

FG

10

100664

3

113640

2

115522

5

ST538

10

125892

10

APR 8 5 2015

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

W 0129449

GENERAL NOTES:

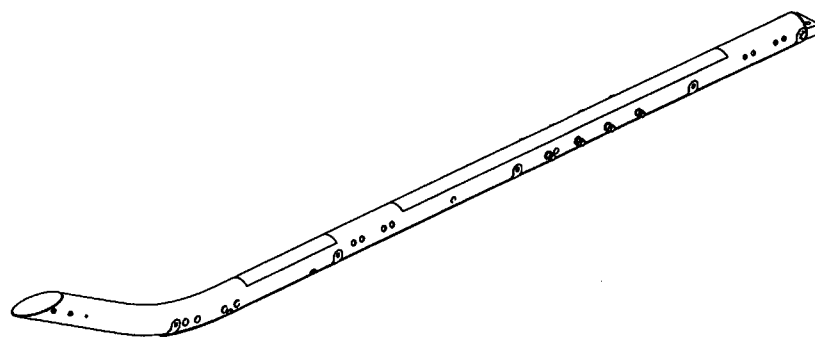
- MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2 1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
B OPTIONAL: POWDER COAT WHITE (REF. 4.3 5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0" ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- WELD PER DART QSI 004
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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2013-08-13
MP

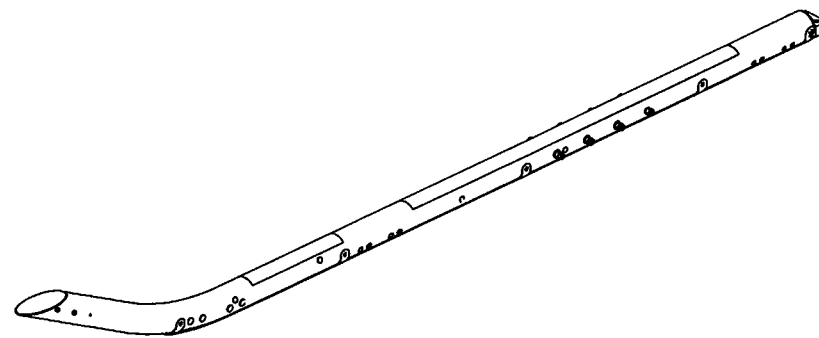
B	ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZND-1-4/-5/-6/-7); UPDATED FINISH OPTIONS. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
A	NEW ISSUE	SC	10.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN	SC		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	SC		
APPROVED	SC		
DE APPR.	SC		
DATE	13.07.11		

DART AEROSPACE USA, INC. KENT, WA	
DRAWING NO. D4168	REV. B
TITLE 350 SKIDTUBE ASSEMBLY	SHEET 1 OF 11
DATE 13.07.11	SCALE NTS

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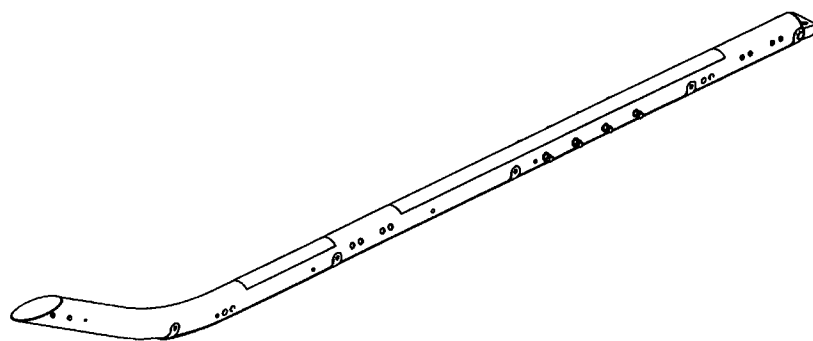
D4168-041 350 SKIDTUBE ASSEMBLY, LH



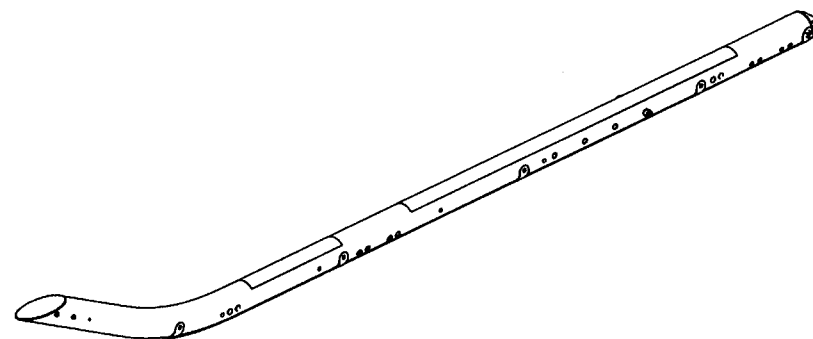
D4168-042 350 SKIDTUBE ASSEMBLY, RH

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MFG. APPR.		D4168	SHEET 2 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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D4168-043 350 SKIDTUBE ASSEMBLY, LH

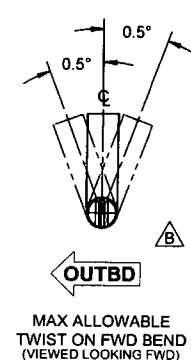
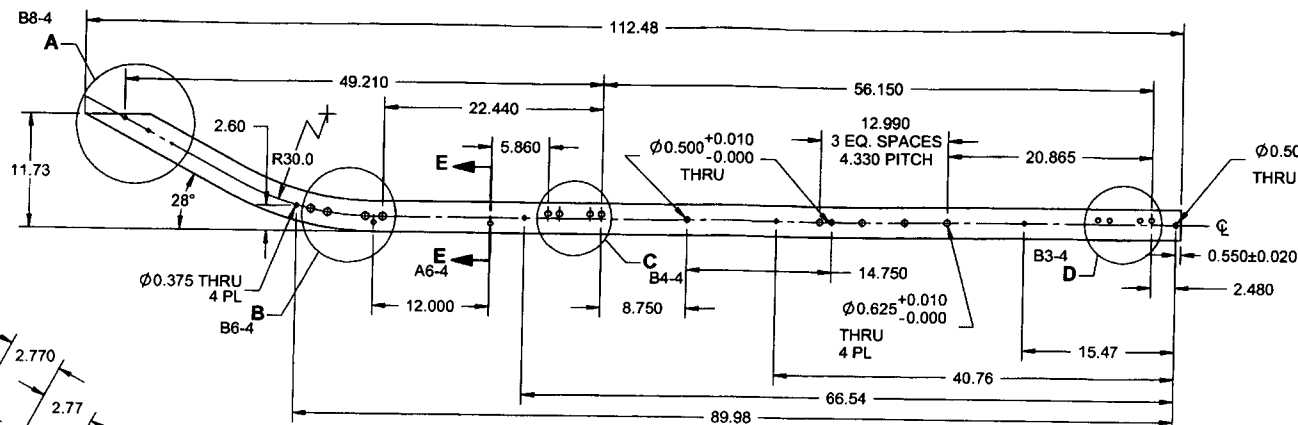


D4168-044 350 SKIDTUBE ASSEMBLY, RH

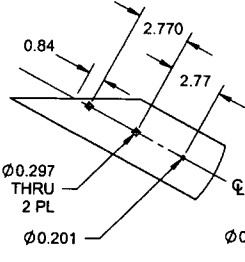
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2013-08-13
AMD

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CHECKED	JP	DRAWING NO.	REV. B
MFG. APPR.	JP	D4168	SHEET 3 OF 11
APPROVED	JP	TITLE	SCALE
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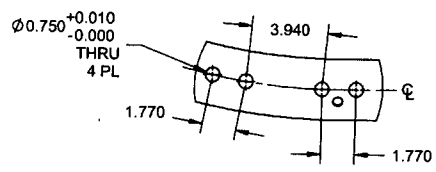
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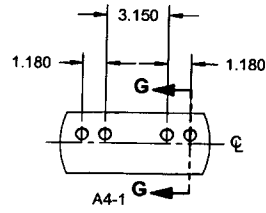
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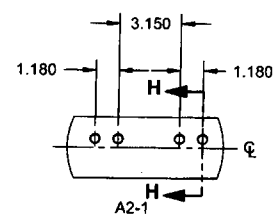
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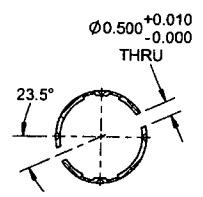
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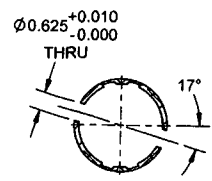
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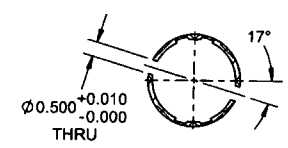
DETAIL D
SCALE 2X



SECTION E-E
SCALE 3X, 2 PL



SECTION G-G
SCALE 3X, 4 PL



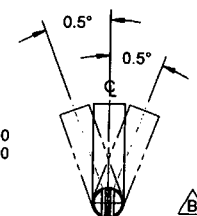
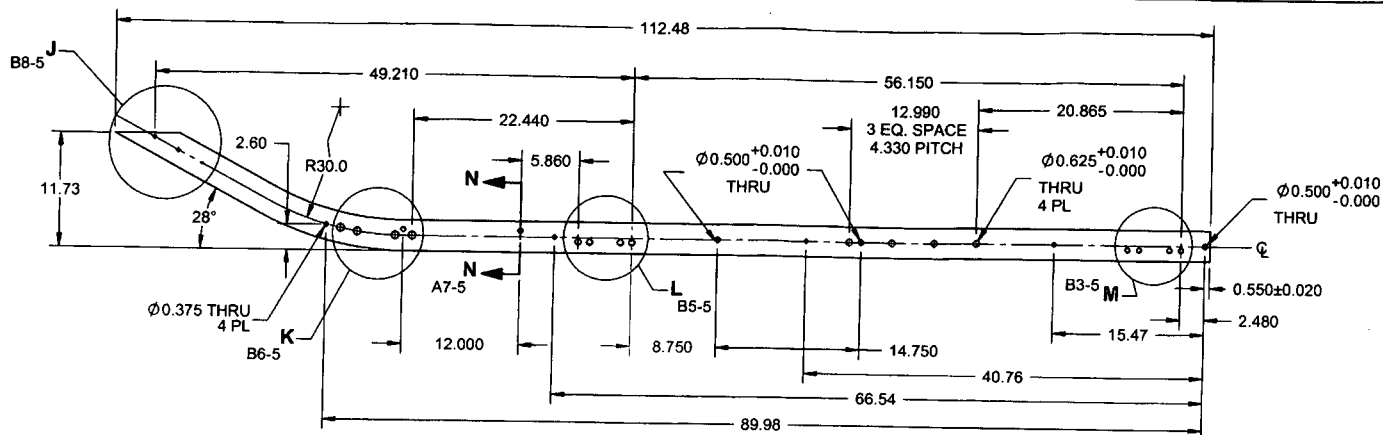
SECTION H-H
SCALE 3X, 4 PL

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APPROVED
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DATE 13.07.11

DART AEROSPACE USA, INC.
KENT, WA
DRAWING NO. D4168
TITLE 350 SKIDTUBE ASSEMBLY
REV. A
SHEET 4 OF 11
SCALE NTS
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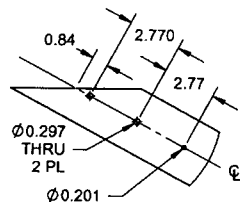
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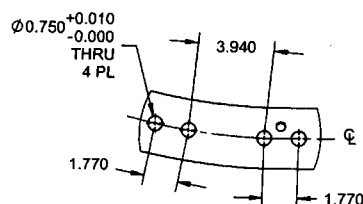
OUTBD

MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

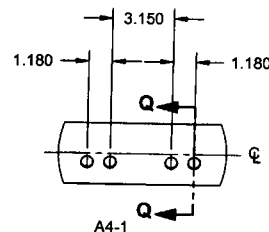
D4168-2 RH SKIDTUBE



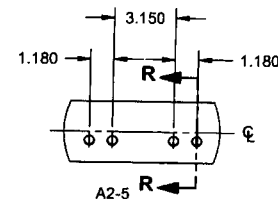
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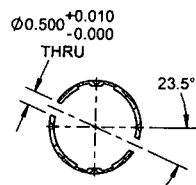
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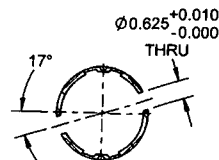
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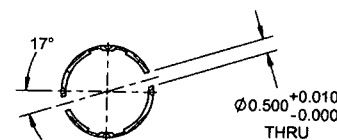
DETAIL M
SCALE 2X



SECTION N-N
SCALE 3X, 2 PL



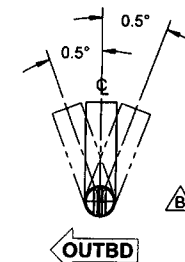
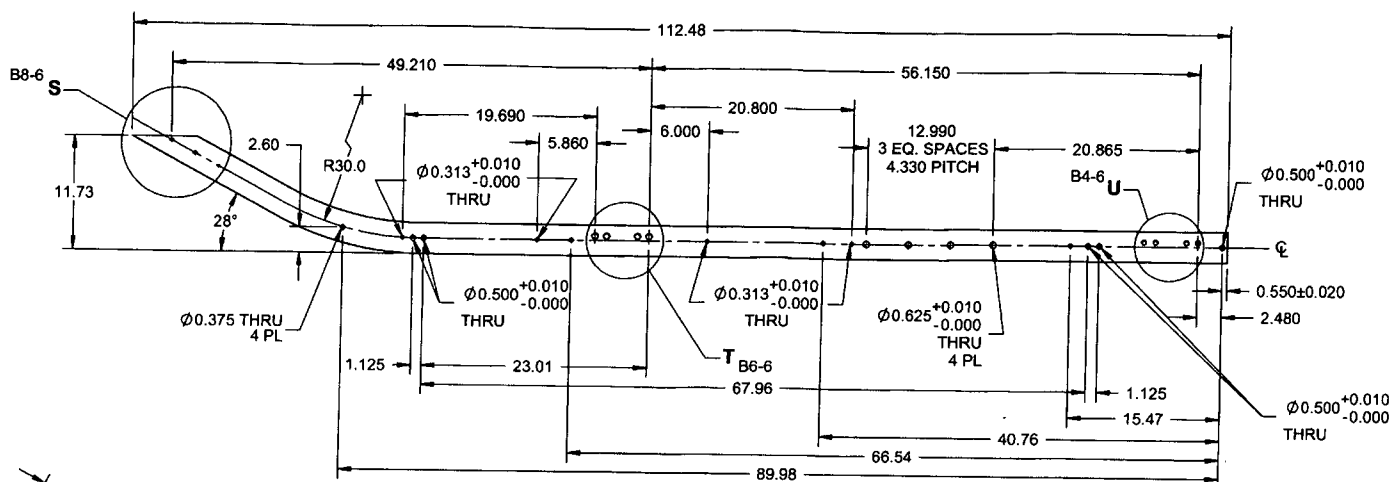
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SCALE 3X, 4 PL



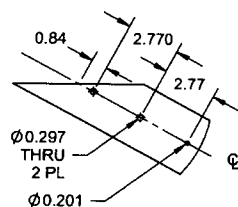
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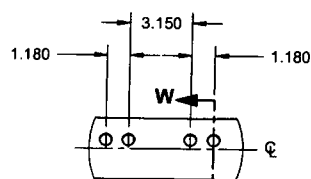
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13.07.11		REV. B SHEET 5 OF 11 SCALE NTS	



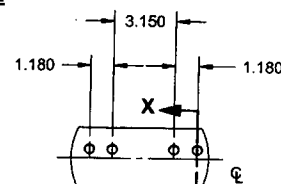
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TWIST ON FWD BEND
(VIEWED LOOKING FWD)



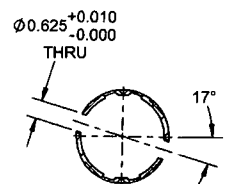
D8-6
DETAIL S
SCALE 2X



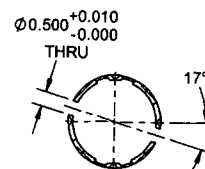
C5-6
DETAIL T
SCALE 2X



D3-6
DETAIL U
SCALE 2X



B6-6
SECTION W-W
SCALE 3X, 4 PL



B4-6
SECTION X-X
SCALE 3X, 4 PL

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DE APPR.
DATE 13.07.11

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KENT, WA

DRAWING NO.
D4168

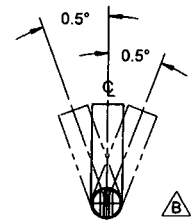
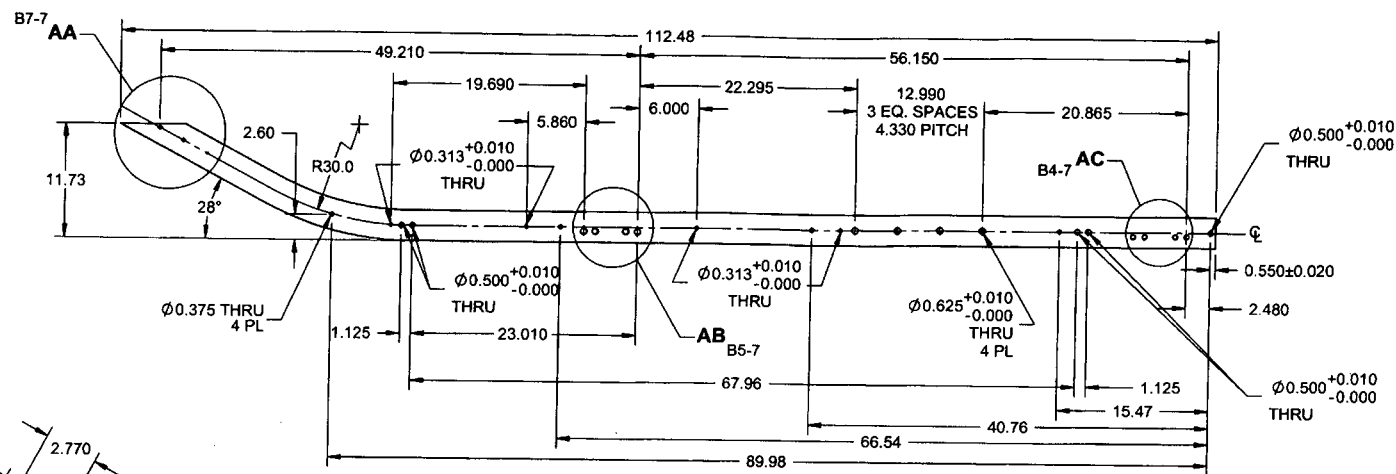
TITLE
350 SKIDTUBE ASSEMBLY

REV. B
SHEET 6 OF 11
SCALE
NTS

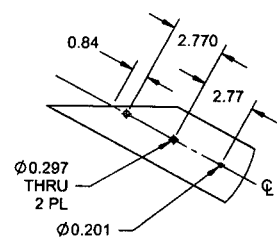
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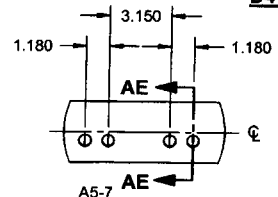
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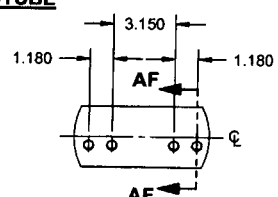
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)



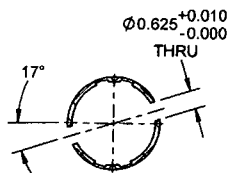
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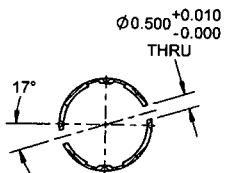
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SCALE 2X



DETAIL AC
SCALE 2X



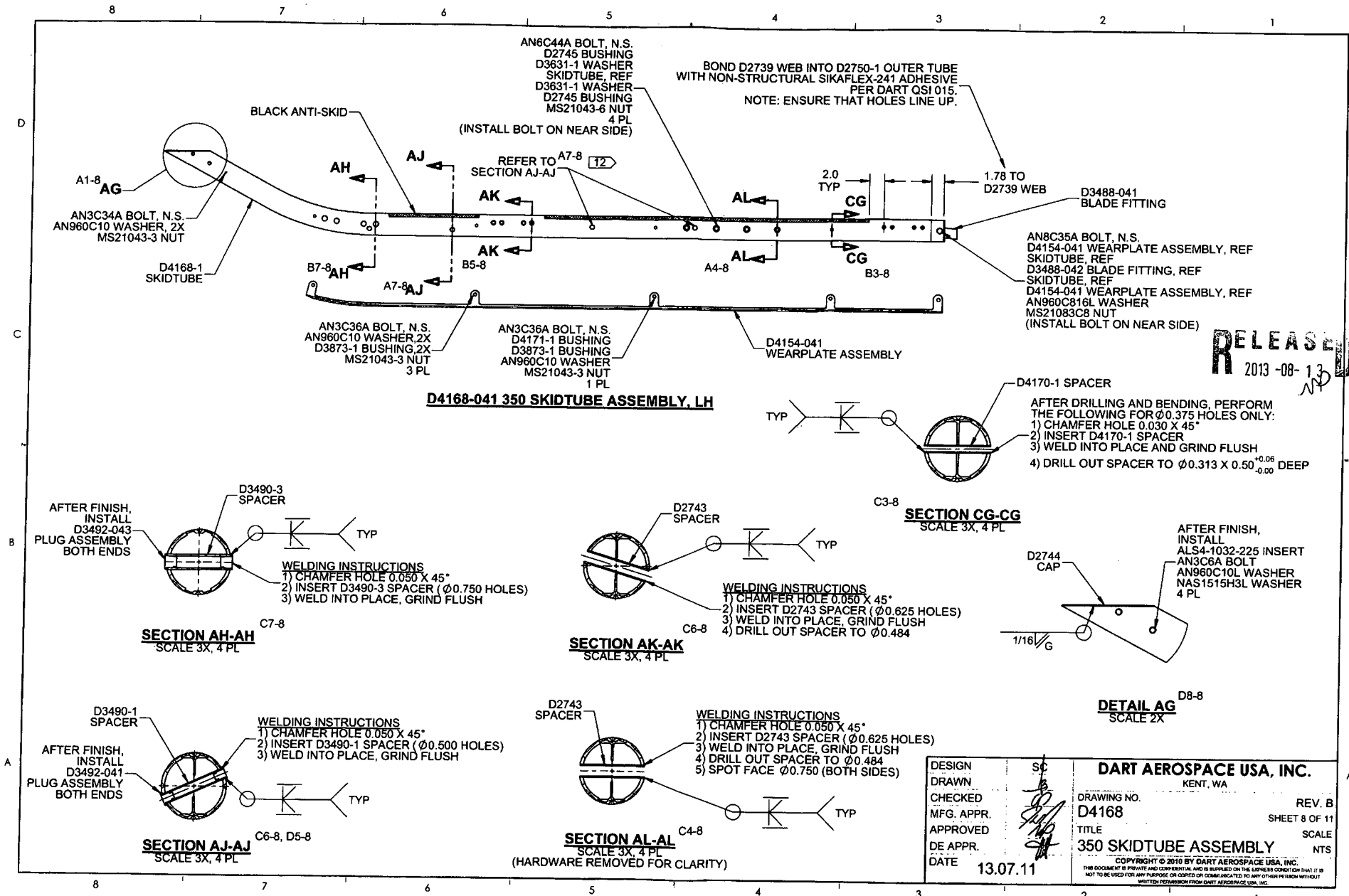
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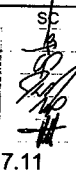
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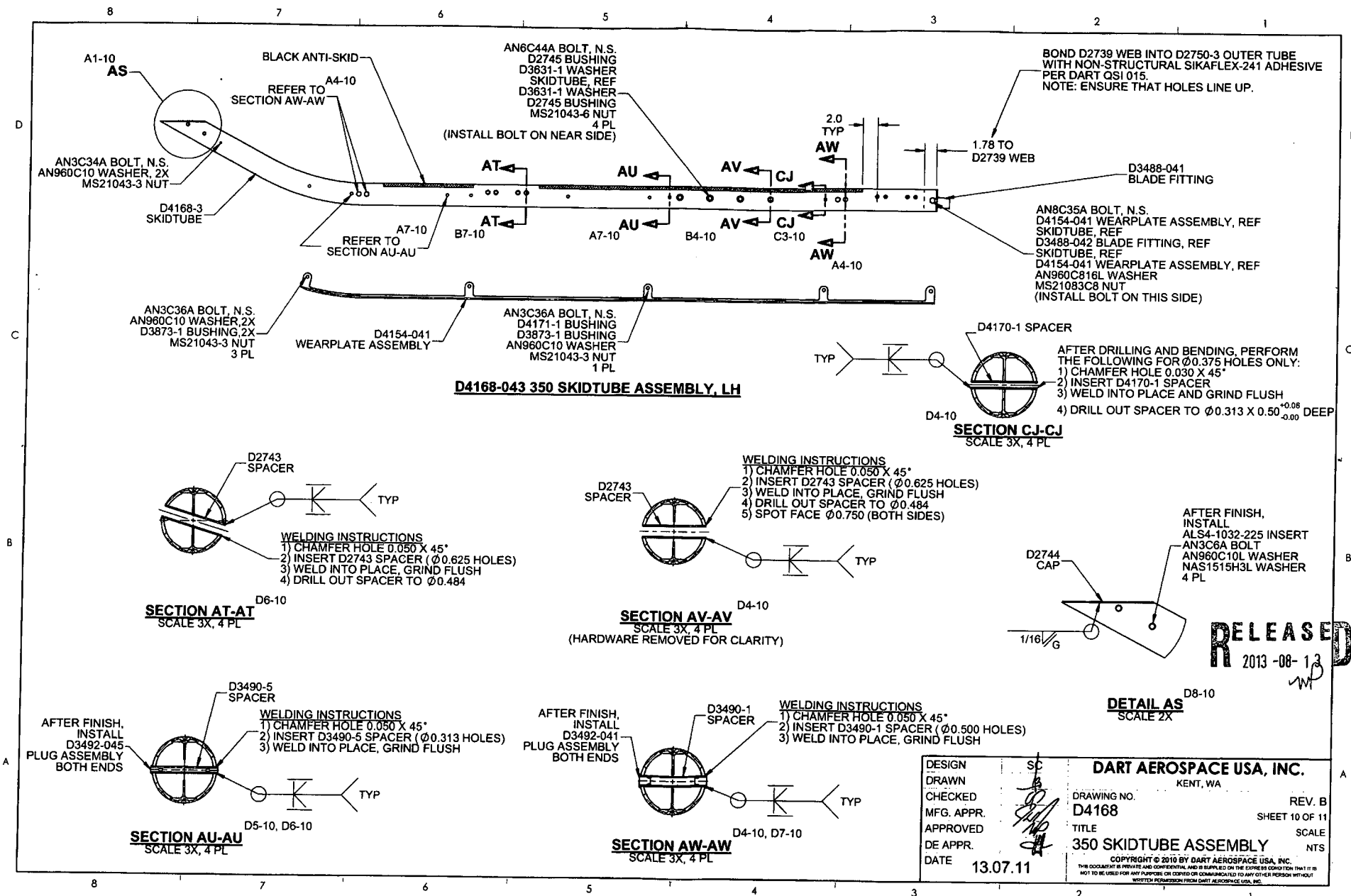
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DATE	13.07.11	SHEET 7 OF 11
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		NTS



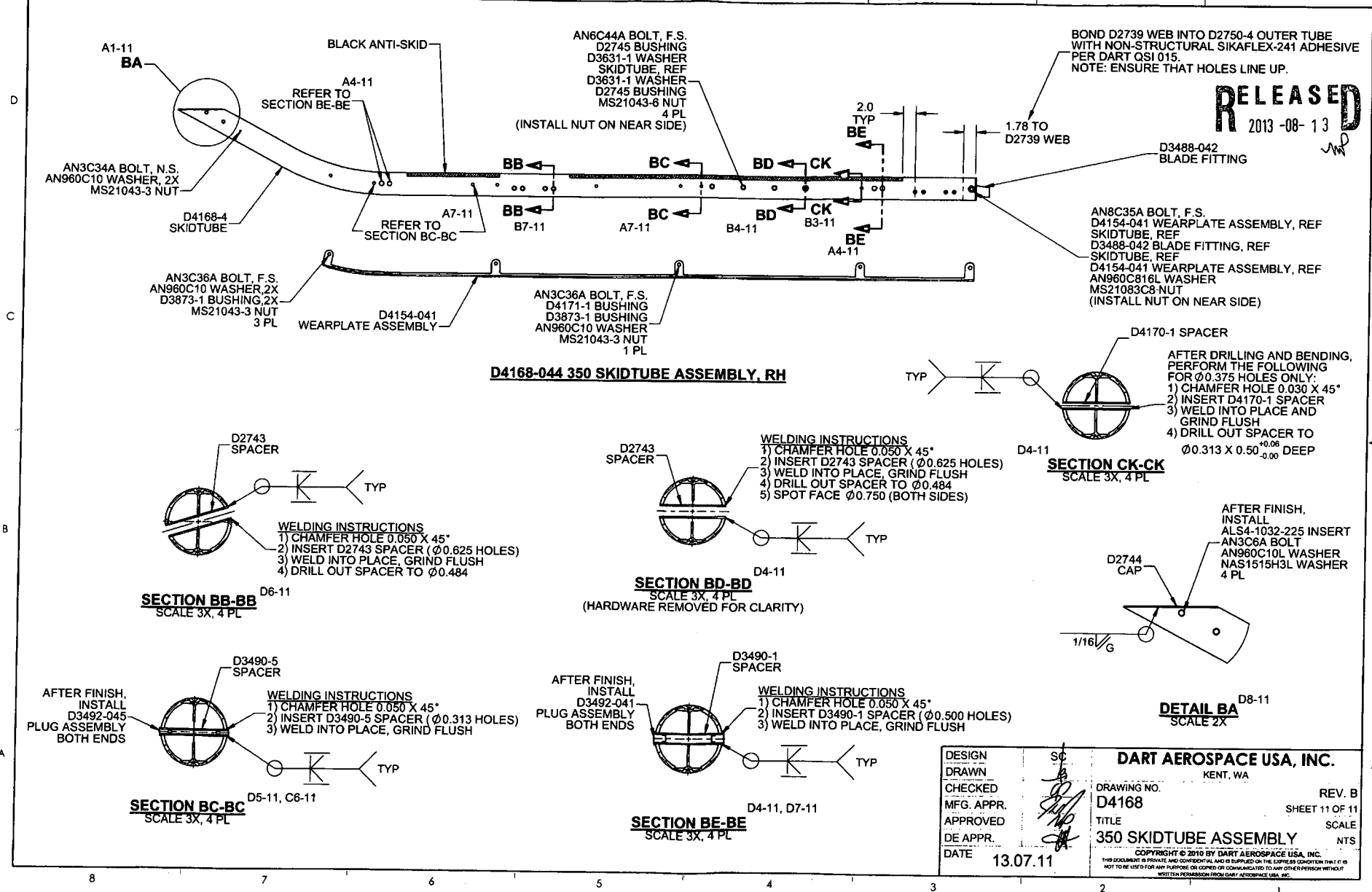
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8 7 6 5 4 3 2 1



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